

Date: Thursday, 2/21/2008 9:26:56 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : END PLATE
Job Number : 37571	
Estimate Number : 10547	
P.O. Number :	Part Number : D30671
This Issue : 2/21/2008 S.O. No. :	Drawing Number : D3067 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 35804	Material :
Written By :	Due Date : 2/27/2008 Qty: 229 Um: 160 Each
Checked & Approved By : <u>1080221</u>	
Comment : Est:03.01.21 Remove step 6 (Deburr) KJ	
Est Rev:B Now on Water jet 06-06-16 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M5052H32S063	5052-H32 .063 Sheet
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Comment: Qty.: 0.0656 sf(s)/Unit Total : 10.5000 sf(s)

5052-H32 .063 Sheet

Material: 5052-H32 (QQ-A-250/8)

M5052H32S.063) or6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063)

Batch:

103785 IB 8-2-22

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3067

Dwg Rev: AIB 8-2-22Prog Rev: A

2-Deburr if necessary

229 PTC
08/02/25 229

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-2-22229

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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08-2-26 229
counted



Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Bend as per Dwg D3067

08/03/03 229

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3067-1 PAR #: N/A Fault Category: Prod / For Ass' made & smd NCR: Yes No DQA: D Date: 08/03/06
 QA: N/C Closed: BJ Date: 08/03/06

NCR: <u>37571</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08-2-26</u>	<u>20</u>	<u>10 parts scrap. -> Too small Set offset was incorrect R.C. operator error</u>	<u>[Signature]</u>	<u>donate for set-up. on broke No replace</u>	<u>HB N/A</u>	<u>[Signature]</u> <u>08-2-26</u>	<u>[Signature]</u> <u>08-2-26</u>	<u>[Signature]</u> <u>08-2-26</u>

NOTE: Date & initial all entries

Date: Thursday, 2/21/2008 9:26:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END PLATE

Job Number: 37571

Part Number: D30671

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO NEXT STEP

02/03/03 (229)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *in A2*

08-03-03 (229)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(229)

Job Completion



mi 2008/3/04

(229)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

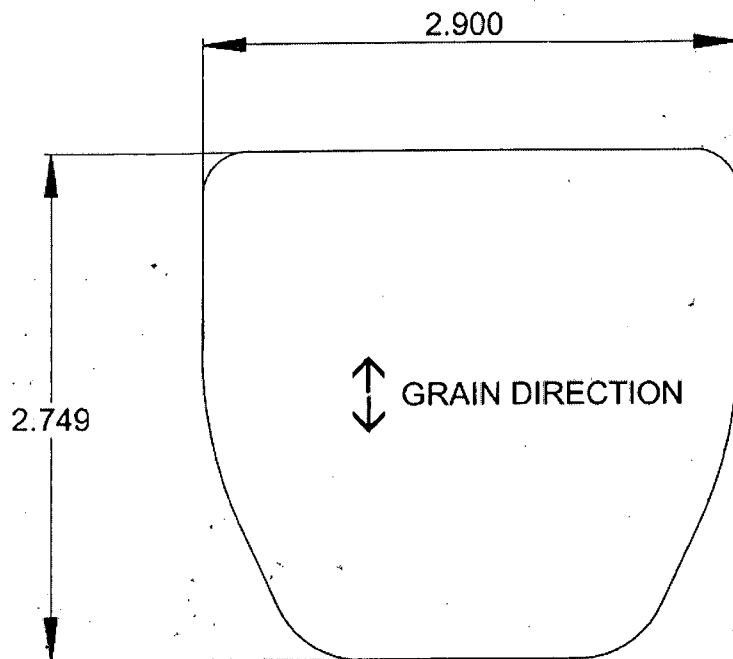
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

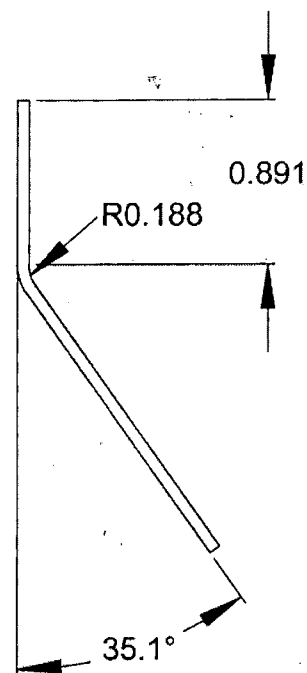


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37571

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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